

Date: Friday, 04/04/2008 9:46:48 AM
User: Julie Lecocq

ASAP

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTER FWD SADDLE
Job Number	: 38365		
Estimate Number	: 11076		
P.O. Number	:	Part Number	: D5951
This Issue	: 04/04/2008 S.O. No. :	Drawing Number	: D5951 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 04/04/2008 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 36459	Material	:
Written By	:	Due Date	: 23/04/2008
Checked & Approved By	: <u>JLD 08.04.4</u>	Qty:	<u>20</u> / <u>16</u> Um: Each
Comment	: Est Rev:E Re-Format 05-11-29 JLM		
	: Est Rev:E Re-Format 05-11-29 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101013	Saddle billet
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)</p> <p>D6101-013 (7075-T7351)</p> <p>Size 2.50" x 10.10" X 8.25" (Grain along 10.10")</p> <p>Batch: <u>331390</u> 1 <u>DTP 08/04/12</u></p>		
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
<p>Comment: HAAS CNC VERTICAL MACHINING #3</p> <p>1-Machine as per folio D5951, Ensure Batch Number is entered</p> <p>2-Machine Keyway</p> <p>3-Deburr & Tumble <u>DTP 08/04/12</u> / <u>2F 08/04/15</u> (20)</p>		
3.0	QC1	INSPECT ALL DIM TO DIM SHEET
<p>Comment: INSPECT ALL DIM TO DIM SHEET <u>2F 08/04/15</u> (20)</p>		
4.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK <u>JL 08/04/15</u></p>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<p>Comment: HAND FINISHING RESOURCE #1</p> <p>Chemical Conversion Coat as per QSI 005 4.1 <u>2F 08-04-17</u> (20)</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:46:49 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 38365

Part Number: D5951

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m107550



(20)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FA 08/04/17

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(21)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-04-17

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 421

SA/4/17

SD (20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38365
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		0.442	0.442	0.442	0.447		
B	1.745	1.755		1.749	1.749	1.750	1.749		
C	5.245	5.255		5.250	5.250	5.250	5.249		
D	6.995	7.005		6.998	6.999	6.999	7.000		
E	5.745	5.755		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.321	0.320	0.321	0.321		
H	1.522	1.532		1.525	1.527	1.526	1.526		
I	3.048	3.058		3.051	3.053	3.052	3.052		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.312	0.319		0.319	0.319	0.319	0.319		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.507	0.500	0.500	0.500		
N	1.615	1.635		1.626	1.625	1.625	1.625		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.249	2.249	2.250		
Q	0.307	0.312		0.312	0.310	0.310	0.310		
R	0.760	0.765		0.762	0.762	0.762	0.762		
S	0.490	0.510		0.4975	0.498	0.498	0.498		
T	1.375	1.395		1.3845	1.3855	1.386	1.3865		
U	2.000	2.020		2.0045	2.006	2.004	2.0045		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	DSP
Date:	08/04/12

Audited by:	J.L
Date:	08/04/15

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

DART AEROSPACE LTD		Work Order:	38365
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.437	0.444		0.442	0.442	0.442	0.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.249	5.250	5.250	5.249		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.749	4.750	4.750	4.750		
G	0.315	0.322		0.321	0.321	0.321	0.321		
H	1.522	1.532		1.526	1.526	1.526	1.527		
I	3.048	3.058		3.053	3.053	3.052	3.052		
J	4.575	4.585		4.580	4.580	4.580	4.579		
K	0.312	0.319		0.319	0.319	0.319	0.319		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.500	0.499	0.499	0.499		
N	1.615	1.635		1.6285	1.628	1.628	1.629		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.249	2.249		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.762	0.762	0.762	0.762		
S	0.490	0.510		0.494	0.497	0.497	0.497		
T	1.375	1.395		1.3855	1.386	1.3853	1.388		
U	2.000	2.020		2.003	2.005	2.003	2.007		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	DTP
Date:	08/04/13

Audited by:	J.L
Date:	08/04/15

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

DART AEROSPACE LTD		Work Order: 38365
Description: Outer Fwd Saddle		Part Number: D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.437	0.444		.443	.443	.443	.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.749	4.749	4.750		
G	0.315	0.322		0.321	0.321	0.321	0.321		
H	1.522	1.532		1.527	1.526	1.526	1.527		
I	3.048	3.058		3.053	3.052	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.312	0.319		0.319	0.319	0.319	0.319		
L	0.495	0.505		0.500	0.500	0.499	0.500		
M	0.490	0.510		0.501	0.501	0.501	0.500		
N	1.615	1.635		1.626	1.627	1.627	1.627		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.249	2.249	2.250		
Q	0.307	0.312		.312	.312	.312	.312		
R	0.760	0.765		.762	.762	.762	.762		
S	0.490	0.510		.505	.501	.500	.500		
T	1.375	1.395		1.388	1.388	1.387	1.387		
U	2.000	2.020		2.008	2.007	2.007	2.007		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DFP	08/04/14
Date:	

Audited by: JL	08/04/15
Date:	

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

DART AEROSPACE LTD		Work Order:	38365
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	13 ⁴	14 ²	15 ³	16 ²		
A	0.437	0.444		.443	.443	.443	.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.526	1.526	1.526	1.526		
I	3.048	3.058		3.052	3.050	3.050	3.050		
J	4.575	4.585		4.579	4.579	4.579	4.579		
K	0.312	0.319		.319	.319	.319	.319		
L	0.495	0.505		.501	.501	.501	.501		
M	0.490	0.510		.500	.502	.502	.502		
N	1.615	1.635		1.627	1.627	1.627	1.627		
O	7.990	8.010		8.002	8.003	8.003	8.003		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.312	.312	.312	.312		
R	0.760	0.765		.762	.762	.762	.762		
S	0.490	0.510		.500	.500	.500	.500		
T	1.375	1.395		1.385	1.388	1.388	1.388		
U	2.000	2.020		2.002	2.005	2.005	2.005		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: B.F.
Date: 08/04/15

Audited by: J.L.
Date: 08/04/15

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: Outer Fwd Saddle		Part Number: D5951	
Inspection Dwg: D5951		Rev: B	
		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	17	18	19	20		
A	0.437	0.444		.443	.443	.443	.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.526	1.526	1.525	1.525		
I	3.048	3.058		3.050	3.050	3.050	3.050		
J	4.575	4.585		4.581	4.581	4.581	4.581		
K	0.312	0.319		.319	.319	.319	.319		
L	0.495	0.505		.501	.500	.500	.500		
M	0.490	0.510		.502	.502	.502	.502		
N	1.615	1.635		1.626	1.627	1.626	1.626		
O	7.990	8.010		8.000	8.003	8.003	8.003		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.312	.312	.312	.312		
R	0.760	0.765		.762	.762	.762	.762		
S	0.490	0.510		.505	.505	.505	.505		
T	1.375	1.395		1.388	1.388	1.388	1.388		
U	2.000	2.020		2.002	2.002	2.005	2.007		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.P.
Date:	08/04/15

Audited by:	J.L.
Date:	08/04/15

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

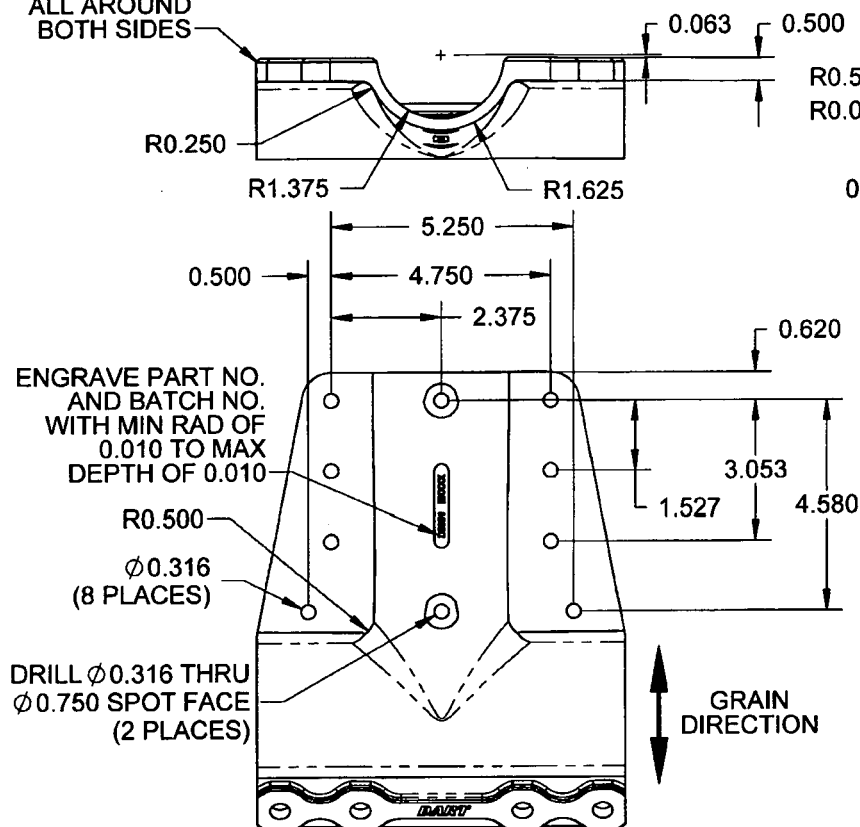
DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5951
DATE 06.11.07	TITLE OUTER FWD SADDLE	REV. B SHEET 1 OF 1
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE
REV B	DATE 06.11.07	DESCRIPTION INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;

CHAMFER
0.075 X 45°
ALL AROUND
BOTH SIDES

RELEASED

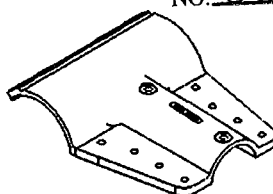
06.11.28

**DETAIL B**
SCALE 1:1**VIEW A-A****D5951 OUTER FWD SADDLE**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38365

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**
SCALE 1:8

COPYRIGHT © 1997 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.